

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022149**Date Inspected:** 26-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Liu Hua Jie ZPMC**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** BAY14 OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Robert A.DeArmond was present during the time noted above and conducted observations relative to the work being performed.

BAY14

This QA Inspector observed the following work in progress:

FCAW welding of complete joint penetration weld joint(s) located on lift 14E, SEG3019Z Longitudinal Diaphragm to Floor Beam weld number(s) 041, 047. Welder is identified as welder no. 068764. The welding variables recorded by ZPMC QC identified as Wang Xiang Pin appeared to comply with applicable WPS(s) WPS-B-T-2234-ESAB.

FCAW welding of complete joint penetration weld joint(s) located on lift 14E, SEG3019Z Longitudinal Diaphragm to Floor Beam weld number(s) 041, 047. Welder is identified as welder no. 066733. The welding variables recorded by ZPMC QC identified as Wang Xiang Pin appeared to comply with applicable WPS(s) WPS-B-T-2231-ESAB.

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## WELDING INSPECTION REPORT

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### TRIAL ASSEMBLY

13AE

This QA Inspector observed the following work in progress:

FCAW welding of complete joint penetration weld joint(s) located on lift 13AE, SEG3007AH Floor Beam I-Rib to Grillage weld number(s) 036, 038, 094. Welder is identified as welder no. 050242. The welding variables recorded by ZPMC QC identified as Zhan Hai Feng appeared to comply with applicable WPS(s) WPS-B-2-2231 ESAB.

FCAW welding of complete joint penetration weld joint(s) located on lift 13AE, SEG3007AH Floor Beam I-Rib to Grillage weld number(s) 106, 114, 116. Welder is identified as welder no. 055564. The welding variables recorded by ZPMC QC identified as Zhan Hai Feng appeared to comply with applicable WPS(s) WPS-B-2-2231 ESAB.

FCAW welding of complete joint penetration weld joint(s) located on lift 13AE, SEG3007L Side Plate I-Rib to Floor Beam weld number(s) 073, 077. Welder is identified as welder no. 068924. The welding variables recorded by ZPMC QC identified as Zhan Hai Feng appeared to comply with applicable WPS(s) WPS(s) WPS-345-SMAW-3G (3F)-FCM-Repair and B-WR20380.

SMAW welding of complete joint penetration weld joint(s) located on lift 13AE, SEG3007L Floor Beam Diaphragm to Floor Beam Diaphragm weld number(s) 001. Welder is identified as welder no. 200113. The welding variables recorded by ZPMC QC identified as Zhan Hai Feng appeared to comply with applicable WPS(s) WPS-345-SMAW-3G (3F)-FCM-Repair and B-WR20507.

SMAW welding of complete joint penetration weld joint(s) located on lift 13AE, SEG3007K Floor Beam Diaphragm to Floor Beam Diaphragm weld number(s) 001. Welder is identified as welder no. 200113. The welding variables recorded by ZPMC QC identified as Zhan Hai Feng appeared to comply with applicable WPS(s) WPS-345-SMAW-3G (3F)-FCM-Repair and B-WR20507.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

As mentioned above between QA and QC concerning this project

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Jim Devy 150-002-6784, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	DeArmond,Robert	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley,Ken	QA Reviewer

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